

Date: Tuesday, 8/21/2007 3:43:32 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT CAP
Job Number : 34184	
Estimate Number : 12929	
P.O. Number : N/A	Part Number : D2646UP
This Issue : 8/21/2007 S.O. No. : N/A	Drawing Number : D2646 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : N/A	Material : N/A
Written By : <u>JA 07.08.22</u>	Due Date : 9/20/2007
Checked & Approved By : <u>JA 07.08.22</u>	Qty: 40 Um: Each
Comment : Est Rev:A New Issue 07-07-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 4438

1-Spin as per Dwg D2646

2-Material release note required

07/08/22
 (40)

2.0	D2646P	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

07/09/04
 (40)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

07/09/05
 (40)

count
 (40)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

2-Open holes to .297 as per Dwg D2646.

3-Deburr

07-09-24
 39

PTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/24

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-09-24	5.0	One part scrap, hole was not formed properly because part moved in vice	<i>[Signature]</i>	Scrap, destroy, replace	SAD 07-09-24	<i>[Signature]</i> 07-09-24	<i>[Signature]</i> 07-09-24	<i>[Signature]</i> 07-09-24

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:32 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 34184

Part Number: D2646UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

6.0 8/21/07 (39)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 07-09-25 (39)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

ALS7132130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

INSERT

Batch: _____

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

N/A

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57443

12.0 8/26 (39)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

13.0 8/26 (39)

Job Completion



U 8-09-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

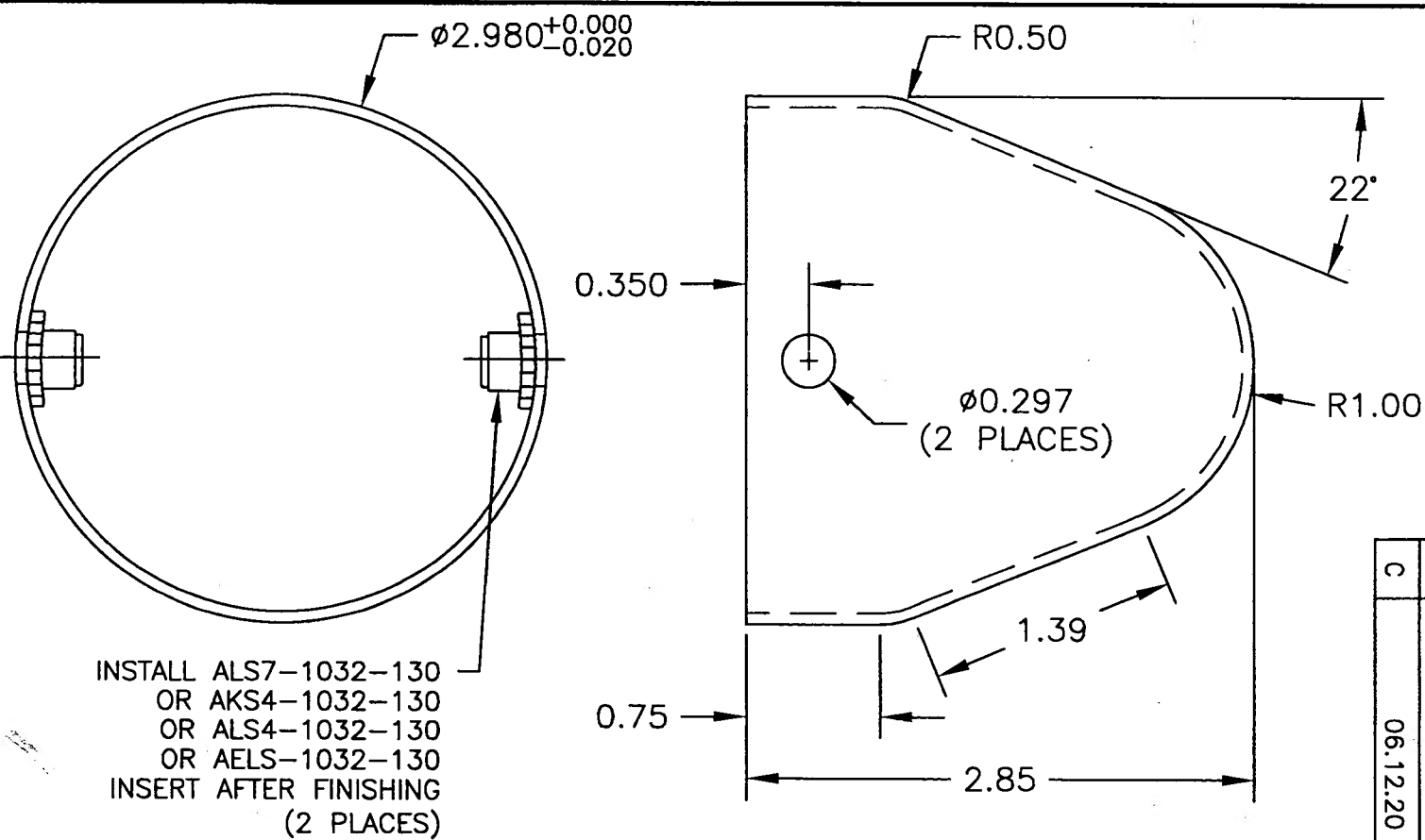
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
DATE	06.12.20			D2646	SHEET 1 OF 1
				TITLE	SCALE
				AFT CAP	1:1
A		97.03.25		NEW ISSUE	
B		05.04.01		CHANGE TO CLOSED INSERTS	
C		06.12.20		CHANGE TO OPEN ENDED INSERTS	



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
07.02.20

NO. 34184
WORK ORDER
34184
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY

ALCOA VIII PRODUCTS
1480 Manheim Pike
Lancaster Pa. 17601

Certification of Test Results

P/N 970200

PO 380880

SOLD TO

SHIP TO

CERT NO 3000675396

DATE 4/23/2007

SKID NO 661032

SKID WGT 5.885

PAGE 1 OF 1

ORDER NO	LG5947	PO NO	43-62756			MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO				
ALLOY	1100	TEMPER	0	FORM	COIL	
GAUGE	.05300	WIDTH	48.0000	LENGTH	0.0000	

LOT: 334171 COIL: B02 DROP: 07TC187

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
U718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI
TAIL ULTIMATE STRENGTH 13.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI
HEAD ELONGATION (G.L. = 2 IN) 32 %
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 C, AMS 4001H 1100 C,
ASTM B209-36 1100 C, AMS-QQ-A-250/1 1100 C
PAX CERTS: 714-736-4840

^^ END OF CERTIFICATION ^^

herby certify that, unless otherwise indicated, the material covered by this report has been
herein, inspected, and tested in accordance with, and has been found to meet, the applicable
described herein, including any specifications forming a part of the description and
representative of the material and the composition. Also, note that mercury is not
present in aluminum alloys and neither it nor any of its compounds are used in the
product. Certification of test results shall not be produced except in full.

Export Administration Regulations. Distribution outside of U.S. is prohibited.

Authorized By:

JEFF KREADY, LAB SUPERVISOR

Order No.: 376276

Part:

FO: 38C880

SALES

Sold to: COPPER &
TR clerk signature:

DART

Purchase Order

Date Aug 22, 2007	Page 1
Purchase Order Number PO00004438	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED
06/03/07

Vendor Address:

Sieg's Manufacturing Ltd.
6236 - 205 Street
Langley, BC V2Y 1N7
Phone (604) 530-7455
Fax (604) 530-7490

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-SIE001	Aug 22, 2007	N30	Fedex	Aug 29, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
✓ 40.0000	D2646P	Aft Cap Comments: AS PER DWG D2646 REV. C B34184 <i>CP 07/09/04</i>	8/29/2007	No	4.96399	Each	198.90
				CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY			
				MATERIAL CERTIFICATION REQ'D UPON DELIVERY			

Comments:**Tax Summary:**

GST
GSTME
GSTND

0.00
0.00

Less:
included tax

0.00

Subtotal

Total tax

Total purchase order in

CAD Dollars

Entered By: *CL* CLAVOIE

Approved By: *U*

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date Sep 5, 2007	Page 1
Receipt Number RCP00005569	

Purchase From:

Sieg's Manufacturing Ltd.
6236 - 205 Street
Langley, BC V2Y 1N7

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number VC-SIE001	PO Number PO00004438
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Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	D2646P	Aft Cap B34184 AS PER DWG D2646 REV. C B/N34184	40.0000	Each	49.5000	49.5000	Sep 05, 2007

Comments:

G.S.T. # R104850649

PACKING SLIP

№ 31516

SOLD TO:

Dart

DATE _____

Aug. 30/2007

CUSTOMER P.O. #

44138

[illegible]

2% interest per month (24% per annum) charged on overdue accounts past 30 days.